



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3512-1

Job Sheet 201457



POSITIVE RECALL

EFFECTIVE 19/10/19 AUTH SAJ

RELEASED DATE

Part No: D3512-1

Job Qty: 12 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/4/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

UNDER REVIEW

UFF 17-745

Note: URF DWG D3512 REV.D IPP Rev:A New Issue 06-06-20 JLM IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD IPP REV:D 13.12.11 ECN13-619/ REV.D DWG DD VERF:JLM IPP REV:D
18.03.12 DWG REV.E12 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12	10/7/19	10/7/19	0.17	1.12	Waterjet - Flow		JRB 10/4/19
110	QC 2	12	10/7/19	10/7/19	0.00	12.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

Date: 10/04/19

PRIORITY

Container No: S219945

Part: D3512-1

Job No: 201457

Serial No/Batch: S219945

Revision: URF/D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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www.dartaerospace.com



120	QC 8	12 pcs	10/7/19	0.00	0.00	QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	JRB 10/14/19
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	DAS 40 9-89 OCT 7 2019
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	DAS 30 9-89
130	Small Fab - Brake NC - B4B	12 pcs	10/7/19	0.25	0.34	Small Fab - Brake - 1 - B4B	OCT 8 2019
						Small Fab - Brake - 2 - B4B	
						Small Fab - Brake - 3 - B4B	
140	QC 5	12 pcs	10/7/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	EL
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
150	Packaging 3-1 - Stock - B4B	12 pcs	10/7/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	



DAS
55
9-89

OCT 0 8 2019

Packaging 3 - 3 - B4B
Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B
Packaging 3 - 14 - B4B
Packaging 3 - 15 - B4B
Packaging 3 - 16 - B4B
Packaging 3 - 17 - B4B
Packaging 3 - 18 - B4B
Packaging 3 - 19 - B4B
Packaging 3 - 20 - B4B
Packaging 3 - 21 - B4B
Packaging 3 - 22 - B4B
Packaging 3 - 23 - B4B
Packaging 3 - 24 - B4B
Packaging 3 - 25 - B4B
Packaging 3 - 26 - B4B
Packaging 3 - 27 - B4B
Packaging 3 - 28 - B4B
Packaging 3 - 29 - B4B
Packaging 3 - 30 - B4B
Packaging 3 - 31 - B4B
Packaging 3 - 32 - B4B
Packaging 3 - 33 - B4B
Packaging 3 - 34 - B4B
Packaging 3 - 35 - B4B
Packaging 3 - 36 - B4B

2

DAS
21
9-89

160 QC 21 - SA 12 10/7/19 0.00 0.00
pcs

QC 21 - SA - 21
QC 21 - SA - 70
QC 21 - SA - 53

OCT 0 8 2019

Part Op 100 - 1-Cut as per Dwg Dwg Rev: E19 Prog Rev: E19 2-Deburr if necessary
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - small fab - Form as per dwg
140 - QC5- Inspect part completeness to step on W/O
150 - Identify as per dwg & Stock Location: W/O
160 - QC21- Final Inspection - Work Order Release

Job BOM

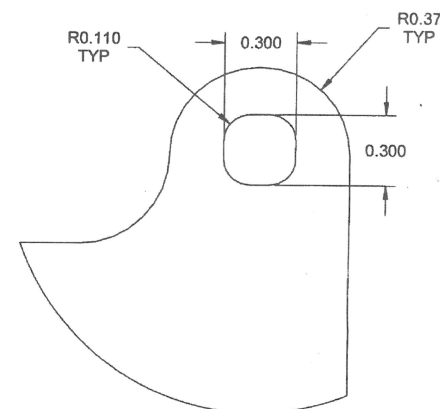
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	3.4800 sf (.29 ea)	100-Waterjet - Flow - 1	5200442

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	3	426	0

Part Specifications

Specifications could not be found.



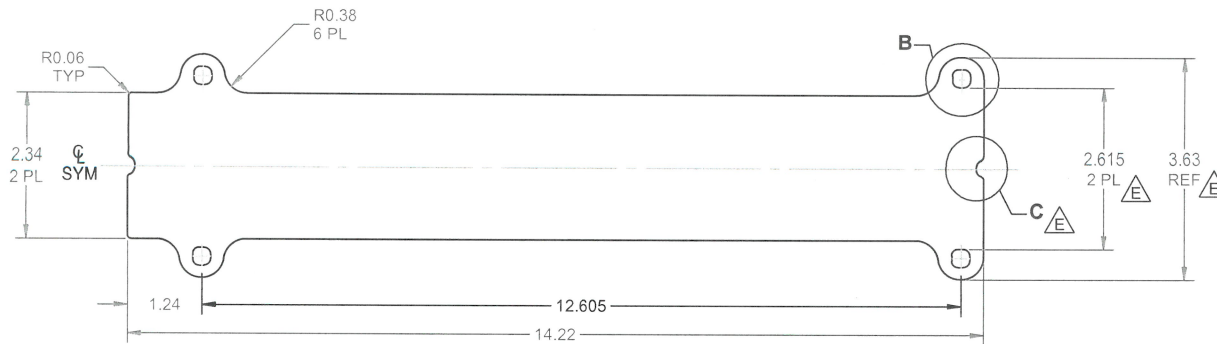
D3512-1F

URF18-745 SAD 18-06-19

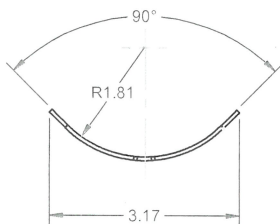
wp

1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.63 lbs

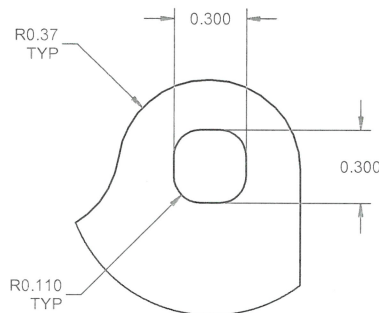
DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3512	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT BEING WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



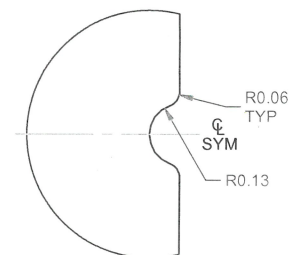
D3512-1F WEARPLATE
(FLAT PATTERN)



D3512-1 WEARPLATE
(MAKE FROM D3512-1F)



DETAIL B
SCALE 4X
4 PL



DETAIL C
SCALE 4X
2 PL

REFERENCE ONLY

WORK IN PROGRESS

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.62 lbs

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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DART AEROSPACE LTD		Work Order:	201457
Description: urea-plate		Part Number:	03512-1
Inspection Dwg: 03512	Rev: F19		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by: JRB	Checked by: 9-89	QC Inspector:
Date: 7/10/19	Date: OCT 07 2019	Date:

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Entered: ZR Date: Oct 23/19



NCR No. 19-7491 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>201457</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D3512-1</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☒ Water Jet ☐ Supplier Quality ☐
Date: <u>19/10/8</u>	Sequence #: <u>100</u>		QTY Affected: <u>12</u>		MRB (QSI042) <u>12</u> <u>19/10/8</u>		
Description Work Order Deviation				Disposition		Completed By	
Make D3512-1 to Rev. E Minor change to Rev. D flt pattern for manufacturability, no change to best final bent acceptable. <u>19/10/8</u>				Acceptable to make D3512-1 Rev. E to fix a minor fit issue from D3512-1 Rev. D. Ref w/o 193591		<u>19-10-8</u>	
						Lead hand / Supervisor <u>19-10-8</u>	
						QC / QA Coordinator DAS 55 9-89 OCT 08 2019	
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					